

(10) A

Date: Monday, 5/15/2006 11:12:19 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE		
Job Number	: 27119					
Estimate Number	: 10937					
P.O. Number	: N/A			Part Number	: D29392	
This Issue	5/15/2006	S.O. No.	: N/A	Drawing Number	: D2939 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	5/15/2006	Type	: MACHINED PARTS	Drawing Revision	: B	
Previous Run	: 26371			Material	: N/A	
Written By	: <u>See Comment Below</u>			Due Date	5/30/2006	Qty: 8 Um: Each
Checked & Approved By	: <u>JL 06.05.15</u>					
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101001	7075-T7351 2X6X6.25	
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s) Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length Batch No: <u>B 25342</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 5-Deburr	<u>JL 06/07/05</u>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	<u>EN 06/07/24 X8</u>
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<u>JL 06/07/05 8</u>
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>EN 06/07/24 8</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

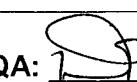
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

DQA: 

Date: 06/07/28

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Monday, 5/15/2006 11:12:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 27119

Part Number: D29392

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
7.0	POWDER COATING	POWDER COATING
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
9.0	PACKAGING 1	PACKAGING RESOURCE #1
10.0	DC	DOCUMENT CONTROL

Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1
SAD 06/07/25 (8)

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
SC DC 06/07/25 (8)

Comment: INSPECT POWDER COAT
AB 06/07/28 (8)

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST2476
R 06/07/28 (8)

Comment: DOCUMENT CONTROL
Inspection Level 21
KJ 06/07/28 (8)

Job Completion



KJ 06.07.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD				Work Order:	27119
Description: 206 Saddle, Inboard, Right side				Part Number:	D2939-2
Inspection Dwg: D2939 Rev. B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.120	.114	.121	.120		
B	0.100	0.140		.120	.115	.119	.120		
C	0.100	0.140		.127	.124	.126	.127		
D	0.210	0.230		.220	.218	.221	.221		
E	1.245	1.255		1.250	1.250	1.251	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.499	2.500	2.500	2.500		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.572	1.582		1.577	1.577	1.577	1.576		
J	2.495	2.505		2.500	2.499	2.499	2.500		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		0.236	0.237	0.236	0.236		
N	0.100	0.140		.120	.110	.120	.120		
O	0.540	0.560		.549	.550	.550	.551		
P	0.490	0.510		.502	.501	.501	.502		
Q	3.715	3.725		3.719	3.719	3.700	3.719		
R	2.720	2.760		2.750	2.750	2.750	2.750		
S	0.240	0.270		.251	.242	.251	.250		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.630	1.629	1.629		
V	1.362	1.372		1.367	1.367	1.367	1.366		
W	0.316	0.321	DT8690						
X	1.250	1.270		1.260	1.260	1.261	1.260		
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL	/	En	Audited by:	JKL	/
Date:	06/07/04	/	06/07/04	Date:	06/07/04	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#

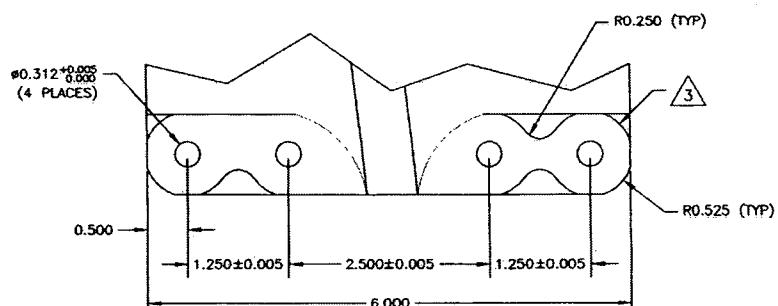
DART AEROSPACE LTD		Work Order:	27119
Description: 206 Saddle, Inboard, Right side		Part Number:	D2939-2
Inspection Dwg: D2939 Rev. B			Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

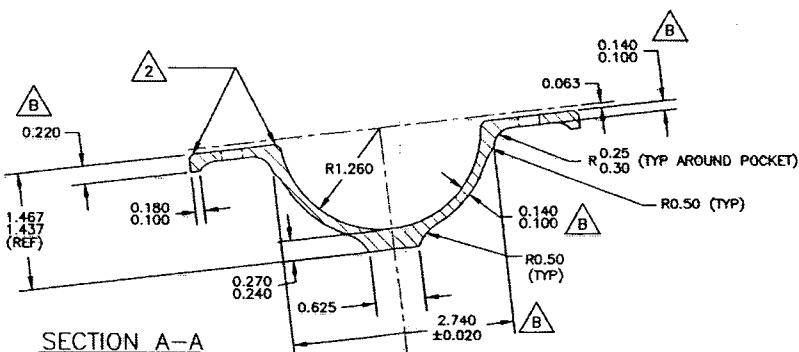
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.121	.120	.120	.121		
B	0.100	0.140		.121	.120	.120	.121		
C	0.100	0.140		.126	.127	.127	.127		
D	0.210	0.230		.220	.223	.220	.222		
E	1.245	1.255		1.250	1.250	1.249	1.250		
F	1.245	1.255		1.249	1.251	1.249	1.250		
G	2.495	2.505		2.499	2.500	2.499	2.500		
H	0.510	0.515		0.512	0.515	0.515	0.515		
I	1.572	1.582		1.578	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.499		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		0.236	0.236	0.236	0.236		
N	0.100	0.140		.121	.122	.121	.121		
O	0.540	0.560		.551	.551	.551	.550		
P	0.490	0.510		.502	.500	.500	.499		
Q	3.715	3.725		3.719	3.720	3.719	3.719		
R	2.720	2.760		2.750	2.750	2.750	2.750		
S	0.240	0.270		.252	.254	.252	.251		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.630	1.629	1.630		
V	1.362	1.372		1.368	1.367	1.367	1.366		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.250	1.270		1.261	1.262	1.260	1.260		
Y	1.565	1.585	DT8695 A/B	/	/	/	/		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL	/	Ep	Audited by:	ml	/	
Date:	06/07/05	/	06/07/24	Date:	06/07/24	/	

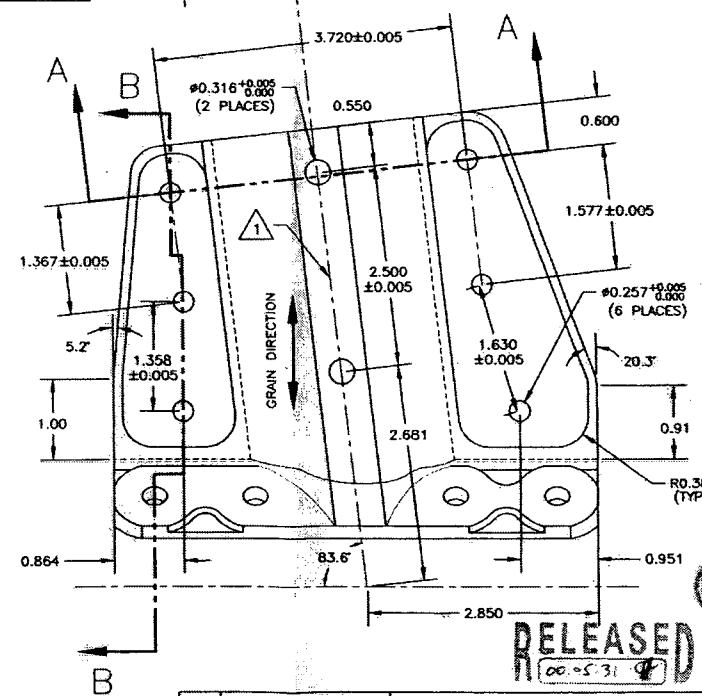
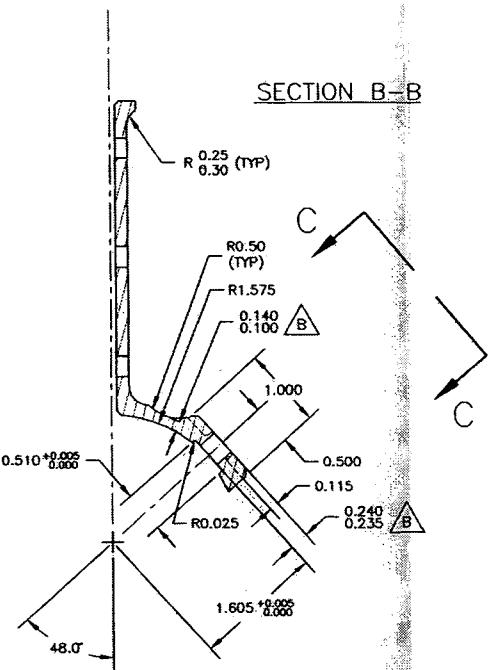
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#



VIEW C-C



SECTION A-A



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 27119

COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2939 SHEET 1 OF 1
DATE	00.05.29	SCALE 2:3
		TITLE SADDLE INSIDE